

19-675-011

Date: Thursday, 19/03/2009 11:01:44 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: A119 STEP WELDMENT LH		
Job Number	: 46571A						
Estimate Number	: 10122						
P.O. Number	:			Part Number	: D3043041		
This Issue	: 19/03/2009 S.O. No. :			Drawing Number	: D3043 REV A		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: / / Type : LARGE FAB ASSY			Drawing Revision	: A		
Previous Run	: 42916A			Material	:		
Written By	:			Due Date	: 10/04/2009 Qty: 4 Um: Each		
Checked & Approved By	: <u>JUL 09.03.19</u>						
Comment	: Est Rev :A New Issue JLM 05-11-01						

Additional Product

Job Number:					
Seq. #:	Machine Or Operation:		Description :		
1.0	D2622120C		Step Extrusion 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)					
Pick:D2622-120 extrusion					
Batch: <u>44064</u> SAD 09-03-19 (4)					
2.0	LARGE FAB 1		LARGE FABRICATION RESOURCE 1 		
Comment: LARGE FABRICATION RESOURCE 1					
1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G					
2-Deburr and bevel ends for welding SAD 09-03-19 (4)					
3.0	QC5		INSPECT WORK TO CURRENT STEP 		
Comment: INSPECT WORK TO CURRENT STEP		<u>10/03/19 (4)</u>			
4.0	D2734		Step End Plate 		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)					
Pick:					
Qty Part Number Description Batch		<u>2 D2734 End Cap 343535</u> 10/03/19 (4)			
5.0	D30401		Mounting Lug 		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)					
Pick:					
Qty Part Number Description Batch		<u>2 D3040-1 Mounting Lug 352944</u> 10/03/19 (4)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 11:01:44 AM
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Drawing Name: A119 STEP WELDMENT LH

Job Number: 46571A

Part Number: D3043041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D30403

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3040-3 Mounting Lug 342945

✓ 09.03.24

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8802
AR AL ROD Batch: M110431

✓ 09.03.24

2-Grind Fwd End Cap weld flush

8.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09.03.25

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.09.03.25 (X) H

10.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Chemical Conversion Coat as per QSI 005 4.1

SAD 09.03.25

④

11.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-1-Weld 1 End Cap as per QSI 004 & Dwg D3043
AR AL ROD Batch: M110130

✓ 09.03.27

2-Inspect for foreign object as per QSI 024

✓ 09.03.27

3-Grind Fwd End Cap weld flush

✓ 09.03.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 11:01:45 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP WELDMENT LH

Job Number: 46571A

Part Number: D3043041

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-03-d9

13.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/03/30 +444H

14.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Fx 09/03/51

1-Touch up Chemical Conversion Coat as per QSI 005 4.1

15.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect alodine

BK 09-04-01

(4)

16.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

11:00

OVEN TEMPERATURE:

320°

FINISH TIME:

11:30

BK 09-04-01

(4)

17.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

m109917

(4)

1-Wing Walk as per Dwg D3043 and QSI 005 4.4

Fx 09/04/01

18.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 09/04/01

(4) LH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 46571A

Part Number: D3043041

Job Number:



Seq. #: Machine Or Operation:

Description :

19.0 PACKAGING 1

PACKAGING RESOURCE #1



4K

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

91419

SY

20.0 QC21

FINAL INSPECTION/W/O RELEASE



09/04/09
HJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF

09-04-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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CHECKED	APPROVED	DRAWING NO.	REV. A
<i>AA</i>	<i>AA</i>	D3043	SHEET 1 OF 2
DATE		TITLE	SCALE
01.06.28		A119 STEP WELDMENT	NTS
A	01.06.28	NEW ISSUE	

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D3043-041	STEP WELDMENT, LH
	X	D3043-042	STEP WELDMENT, RH
1	1	D2622-120	STEP EXTRUSION
2	2	D3040-1	MOUNTING LUG
2	2	D3040-3	MOUNTING LUG
2	2	D2734	ENDPLATE

NOTES:

- 1) MANUFACTURE FROM D2622-120 EXTRUSION
- 2) WELD PER DART QSI 004. ALL WELDS SHOULD BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004
- 3) FINISH: ACID ETCH & ALODINE ASSEMBLY PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT TOP SURFACE OF STEP TO BOTTOM OF TOP RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
01.07.05 *AA*

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WORK ORDER

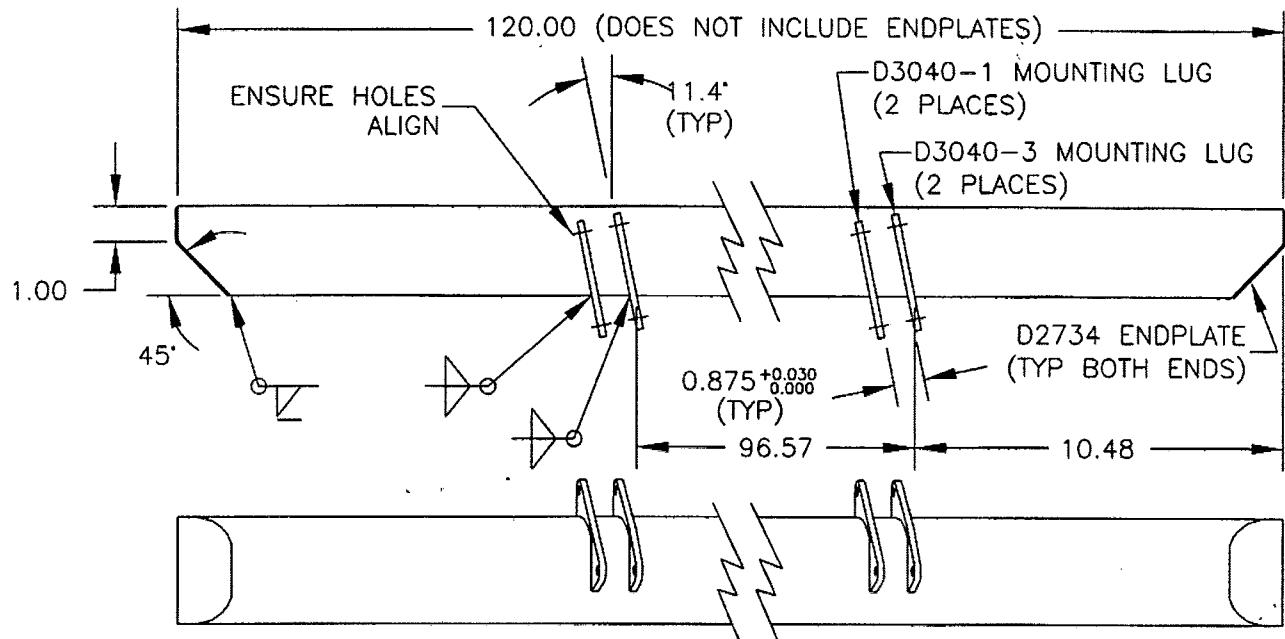
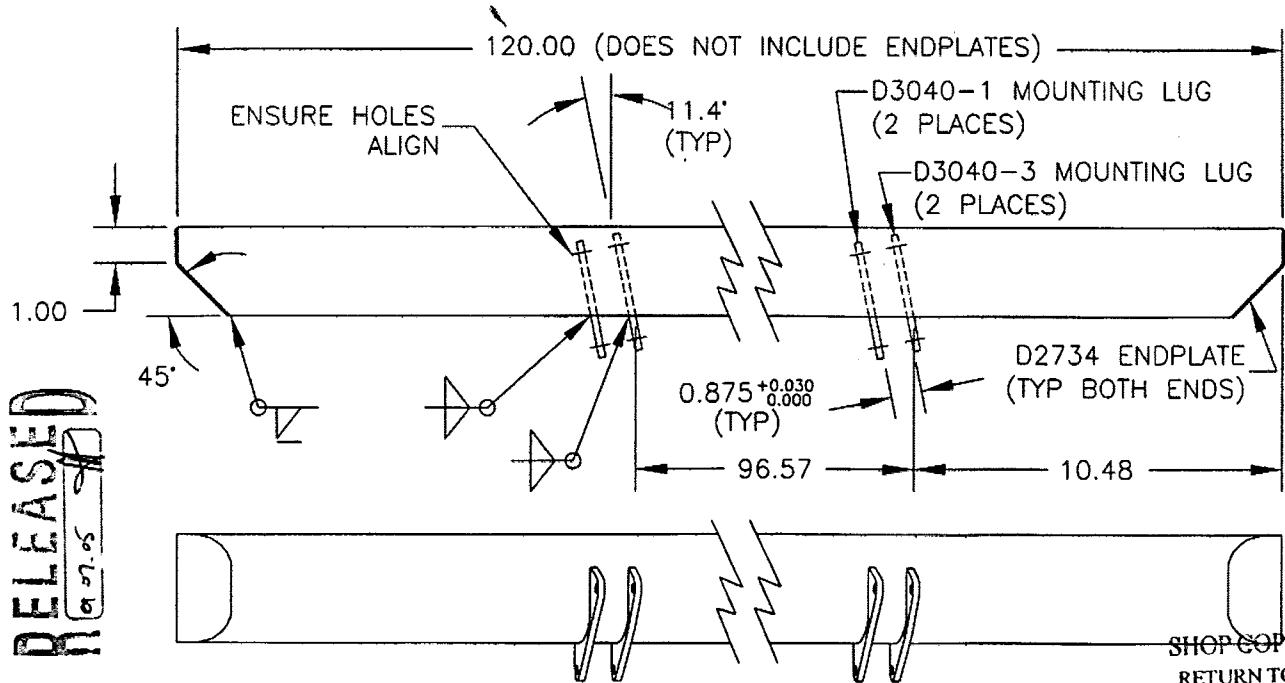
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CHECKED	APPROVED	DRAWING NO.	REV. A
		D3043	SHEET 2 OF 2
DATE	TITLE	SCALE	
01.06.28	A119 STEP WELDMENT	1:5	
A	01.06.28	NEW ISSUE	

VIEW A-A: D3043-041 LH STEP WELDMENTVIEW A-A: D3043-042 RH STEP WELDMENT

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